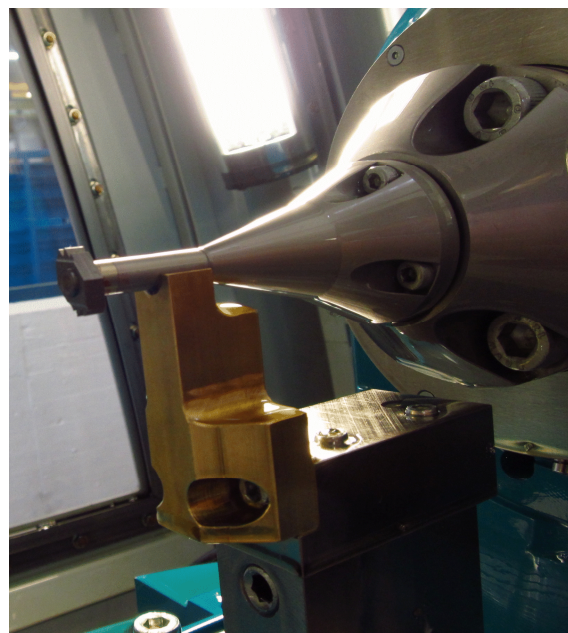
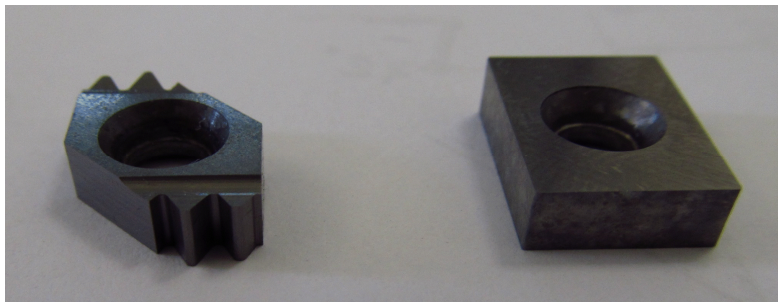


Thread Insert 2-Sided 10 x 12.86

A08-100

The Insert is produced from a rough blank. All the sides are ground to size oscillating a 12A2 wheel keeping the coating permanently in contact. Infeed per oscillation is 0.01 mm.



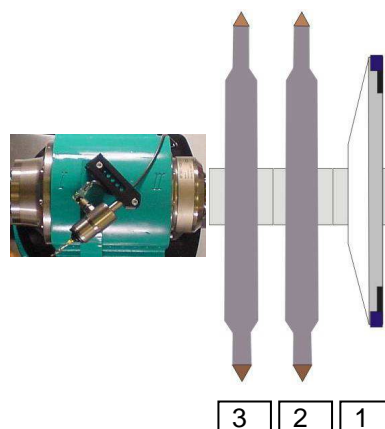
1. Cycletime for Production

Workpiece:	Blank 10 x 13 x 4 mm, TTC Clamping, Chip Breaker 10° rake Material CARBIDE						
Operations							
Feed [mm/Min]	2000	5000	5000	40	70	1500	9000
Power [kW]		4	4	3	2	2	
Cutting feed [m/s]		20	20	20	22	22	
Used wheels							
Grinding time [s]	10	61	61	53	34	31	12
Total cycle time	4 Min 22						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø250 D64
2	14V1 Ø300 D76
3	14V1 Ø300 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 310i Software: Quinto 5
Accessories: Robot
Responsible engineer: OP, 1.5.11

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